



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada
Tel (613) 632-5200
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D2435
Job Sheet 186827



Part No: D2435

Job Qty: 4 ea

Part Name: Bearpaw



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/21/18

Job Tracking No:

Due Date: 11/30/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV E1

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	11/30/18	11/30/18	0.00	0.00	Start Up Container		02-18/11/23
120	Waterjet Flow B4B	4 pcs	11/30/18	11/30/18	0.00	0.67	Waterjet 3 OMAX		02-18/11/23
130	CNC Vertical Machining	4 pcs	11/30/18	11/30/18	0.41	4.06	HAAS 1		52 18/15/24
150	QC	4 pcs	11/30/18	11/30/18	0.00	0.00	QC8		0.89 18/15/24
151	Packaging	4 pcs	11/30/18	11/30/18	0.00	0.00	Packaging3		6 JAN 07 2019
190	QC21-SA	4 Ea	11/30/18	11/30/18	0.00	0.00	QC21		21 0.69 JAN 07 2019

Part Op 120 - CUT BLANK AS PER FILE D2435

Descriptions: 130 - 1-Inspect material for defects or damage prior to machining 2-Machine as per Folio FA789 and Dwg D2435 Identify as D2435

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MUHMWB10	UHMW 1" Black - 48"x120" Tivar Mfg.#52480104	12.8000 sf (3.2 ea)	90-Start up Operation	5045598

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MUHMWB10	13	433	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bearpaw	0.063Inches + 0.030 - 0.010	0.093 0.053		0.063
2	Bearpaw	45.000Degrees ± 0.030	45.030 44.970	Angle	45
3	Bearpaw	5.500Inches ± 0.030	5.530 5.470		5.500
4	Bearpaw	0.200Inches ± 0.030	0.230 0.170		0.200
5	Bearpaw	0.250Inches ± 0.010	0.260 0.240	Radius	0.250
6	Bearpaw	0.250Inches ± 0.030	0.280 0.220		0.250

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																			
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Description Work Order Deviation				Disposition																																							
Dart Aerospace Ltd. 1270 Aberdeen Street Heckesbury, ON K64 1K7 CANADA TEL.: 1 813 632-5200 Email: sales@dartaero.com www.dartaero.com Barcode Container No: S140149 Part: D2435 Job No: 186827 Serial No/Batch: S140149 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's Date: 12/24/18																																											
<table style="width:100%; border: none;"> <tr> <td style="width:15%;">Environment ☐</td> <td style="width:15%;">Power Loss/Surge ☐</td> <td style="width:15%;">Positioned Wrong ☐</td> </tr> <tr> <td>Design ☐</td> <td>Folio/Program ☐</td> <td>Outside Dimensions ☐</td> </tr> <tr> <td>Doc/Data ☐</td> <td>Grain ☐</td> <td>Over/Under tolerance ☐</td> </tr> <tr> <td>Equip/Tooling ☐</td> <td>Weld ☐</td> <td>Part Incorrect ☐</td> </tr> <tr> <td>Handling/Pre ☐</td> <td>Wrong Stock Pulled ☐</td> <td>Part Lost/Missing ☐</td> </tr> <tr> <td>Material ☐</td> <td>Out of Sequence ☐</td> <td>Part Moved ☐</td> </tr> <tr> <td>Internal Transport ☐</td> <td>Off-set ☐</td> <td>Drawing ☐</td> </tr> <tr> <td>Tribal Knowledge ☐</td> <td>Mislabeled ☐</td> <td>Finish ☐</td> </tr> <tr> <td>LOA ☐</td> <td>Fit/Function ☐</td> <td>Misread ☐</td> </tr> <tr> <td>Substation ☐</td> <td>Misaligned/off center ☐</td> <td>Turning Sequence ☐</td> </tr> <tr> <td>Past Expiry Date ☐</td> <td></td> <td></td> </tr> <tr> <td>Misidentified ☐</td> <td></td> <td></td> </tr> </table>								Environment ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Mislabeled ☐	Finish ☐	LOA ☐	Fit/Function ☐	Misread ☐	Substation ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐			Misidentified ☐		
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OTHER : _____																																											

7	Bearpaw	0.625Inches ± 0.030	0.655 0.595	0.630
8	Bearpaw	0.250Inches ± 0.010	0.260 0.240	0.250
9	Bearpaw	45.000Degrees ± 0.000	45.000 45.000	Angle 45°
10	Bearpaw	0.375Inches ± 0.010	0.385 0.365	0.380
11	Bearpaw	19.000Inches ± 0.030	19.030 18.970	19.000
12	Bearpaw	0.950Inches + 0.030 - 0.010	0.980 0.940	0.950
13	Bearpaw	0.260Inches + 0.005 - 0.000	0.265 0.260	Diameter Ø 0.260
14	Bearpaw	0.930Inches ± 0.030	0.960 0.900	Diameter Ø 0.930
15	Bearpaw	0.300Inches + 0.030 - 0.000	0.330 0.300	0.315
16	Bearpaw	0.375Inches ± 0.030	0.405 0.345	0.375
17	Bearpaw	7.375Inches ± 0.030	7.405 7.345	7.375
18	Bearpaw	4.250Inches ± 0.010	4.260 4.240	4.250
19	Bearpaw	2.000Inches ± 0.030	2.030 1.970	2.000
20	Bearpaw	9.000Inches ± 0.010	9.010 8.990	9.000
21	Bearpaw	15.750Inches ± 0.030	15.780 15.720	15.750

Plex 11/21/18 3:00 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								